

Work Order ID 86448

June-29-12 8:05:53 AM

Ship today 29/06

86448

Page 1

Item ID: D4422-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 6/29/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/29/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4422

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

10

12-06-29

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

10

12/06/29

115

Chemical Conversion Coat per QSI005 4.1

0.00

115

HandFinish

Memo

0.00

Hand Finishing

10

12/06/29

Work Order ID 86448

86448

Page 2

June-29-12 8:05:53 AM

Item ID: D4422-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Shim
Start Date: 6/29/12 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/29/12 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
117	QC7-Inspect Chemical Conversion Coat	0.00							
117						10	0		12-6-2012
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>084</u>	0.00							
120						10			12/06/29 JB
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									12/7/3
QC	Memo	0.00							
Quality Control									

MF
12-06-29

Picklist Print

June-29-12 8:05:53 AM

Page 1

Work Order ID: 86448

Parent Item: D4422-1

Parent Item Name: Shim

Start Date: 6/29/12

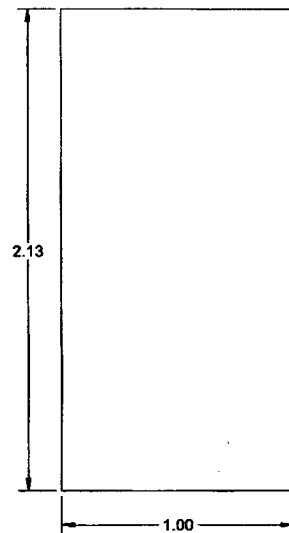
Required Date: 6/29/12

Start Qty: 10.00

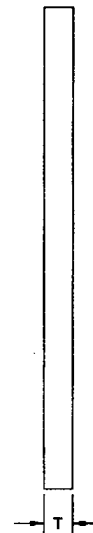
Required Qty: 10.00

Comments: IPP revA 11.06.30 new issue ec verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No				sf	33.4576		0.1694737		10	FF 12-06-29
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				MAT021			33.4575526						
				121473			33.4575526			0.1694737			



D4422-X SHIM



P/N	T THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

- D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6S
D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1
7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

w/o 86448

RELEASED
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4422** REV. A
SHEET 1 OF 1

TITLE **SHIM** SCALE NTS

COPYRIGHT © 2011 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.